

Date: Wednesday, 23/07/2008 12:49:37 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLADE  
 Job Number : 40724  
 Estimate Number : 10327  
 P.O. Number :  
 This Issue : 23/07/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : MACHINED PARTS  
 Previous Run : 38558  
 Written By :  
 Checked & Approved By : JLD 08.7.23  
 Comment : Est Rev: D 00.11.15 Removed P/O turning - in house  
 processEC  
 Est Rev: E 06-03-20 As Per Rev C  
 JLM  
 Est Rev: F 06.04.20 Added grinding after heat treating EC

Part Number : D2741  
 Drawing Number : D2741 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 22/08/2008 Qty: 40 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NB0500X03000 4130 Bar 0.500 x 3.00



Comment: Qty.: 1.2118 f(s)/Unit Total: 48.4722 f(s)

4130 BAR 0.5 x 3.0"

Material: 4130 steel bar 0.50" x 3.00"

Batch: M107965

\*can't remove from computer

MR 08/08/02

(40)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 13.850" long +0.063" -0.000"

SA 08/08/02

(40)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA108

SA 08/08/02

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 23/07/2008 12:49:37 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE

Job Number: 40724

Part Number: D2741

Job Number:



Seq. #:

Machine Or Operation:

Description :

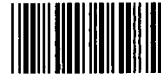
12.0

POWDER COATING

POWDER COATING



M 108523



40X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50  
400 °F  
1:20

m-l 08/09/12

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/9/12

lu

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46p

8/9/12

lu

40X

15.0

QC21

FINAL INSPECTION/W/O RELEASE



40X

Comment: FINAL INSPECTION/W/O RELEASE

2008/09/12

Job Completion



u 08.09.12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

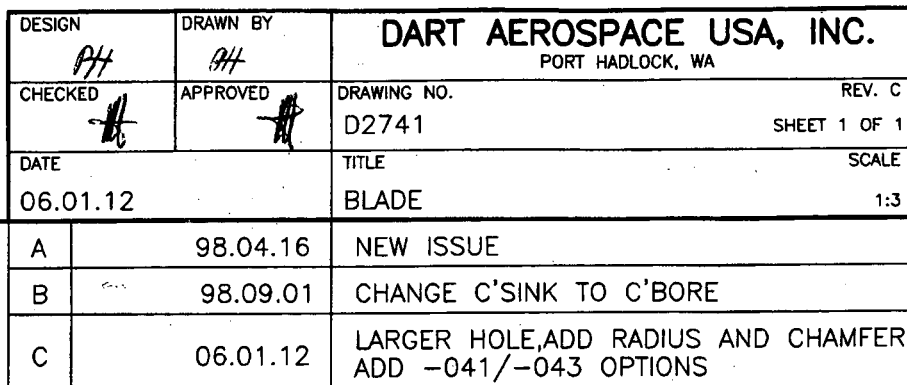
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

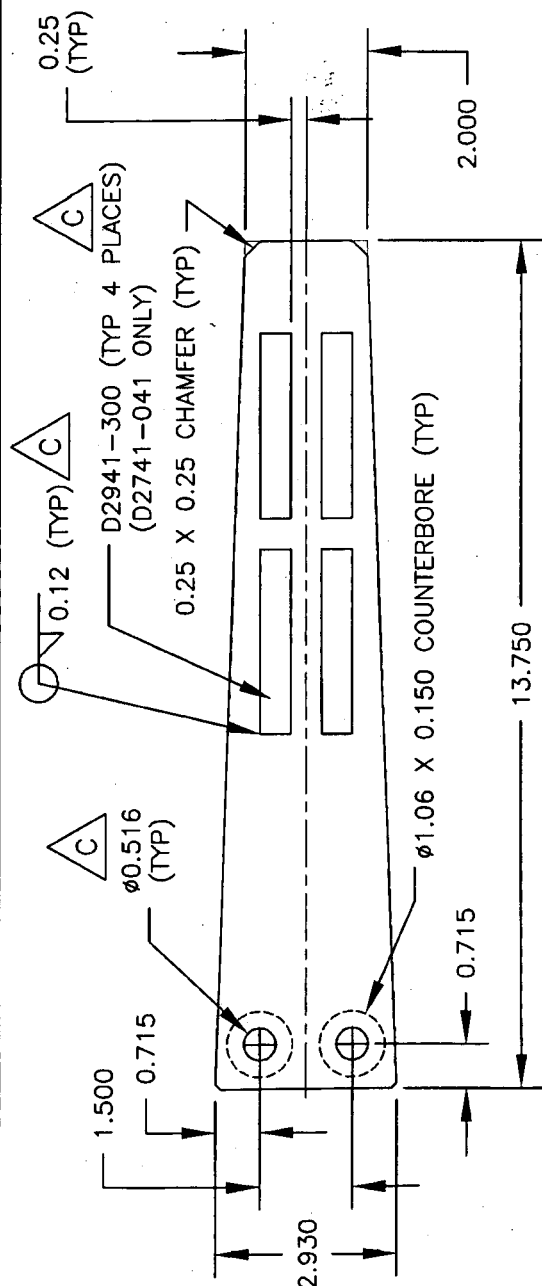
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

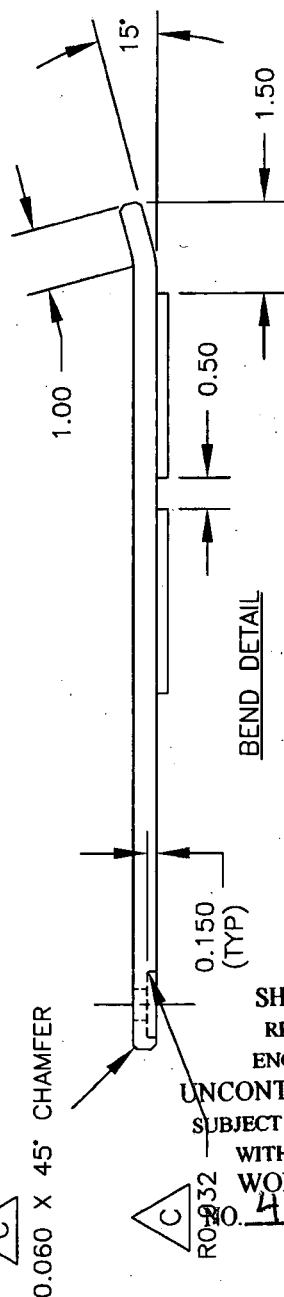




RELEASED  
06 02 07




FLAT PATTERN



SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
ECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

D2741 BLADE

- 1) MATERIAL: AISI 4130 STEEL 0.375 THICK  
MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)  
MIN. YIELD TENSILE STRENGTH = 141 ksi
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.030 TO 0.060
- 6) TO MAKE D2741-041, WELD D2941-300 (4) AS SHOWN ABOVE.  
REMOVE POWDER COAT FROM SURFACE OF D2941-300
- 7) TO MAKE D2741-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300
- 

Copyright © 1998 by DART AEROSPACE USA, INC.

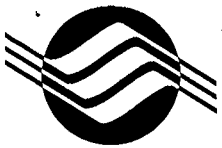
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



121 13 14



121 13 14



**VAC AERO**  
INTERNATIONAL INC.

# PACKING SLIP

OAK 101974-1



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No. : R105468102

09/09/2008

MM / DD / YYYY

PAGE : 1

BILL TO: 1DAR01  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
09/09/2008		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00007011		NET 30 DAYS

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D2741	B40724	EA	40	40	0
		Process Specifications: Procedure: 4161 HARDENED TO 152 KSI MINIMUM 100% HARDNESS TESTED PER ASTM E-18, 34-40 HRC MATERIAL: 4130				
02	MC	MINIMUM CHARGE 150 LBS @ \$2.35/LB		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS





**VAC AERO**  
INTERNATIONAL INC.

**RELEASE NOTE**

GST No.: R105468102

OAK 101974-1

☒ HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489

☐ 2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6L 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380

☐ QUEBEC DIVISION  
7450 RUE VERITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

09/09/2008

MM / DD / YYYY

PAGE : 1

BILL TO: 1DAR01  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
09/09/2008		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00007011		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2741	B40724	EA	40	40	
Process Specifications: Procedure: 4161 HARDENED TO 152 KSI MINIMUM 100% HARDNESS TESTED PER ASTM E-18, 34-40 HRC MATERIAL: 4130					

**100% HARDNESS TESTED**

40 pcs → 36/37 HRC



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS

